

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013790**Date Inspected:** 14-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check on longitudinal diaphragm using 1M straight edge to check Offset for below segment. Reports forwarded to team leader for further action

7BE-7CE

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check on deck panel diaphragm using 710mm straight edge and right angle to check plumpness and flatness for below segment. Reports forwarded to team leader for further action

7CE -PP 55

7DE -PP 58

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check on floor beam using 1.5M straight edge to check flatness for

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below segment. Reports forwarded to team leader for further action

7CE – PP 53, PP 54 and PP 55

7DE – PP 56, PP 57 and PP 58

7EE – PP 59 and PP 60

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (7DE)

FCAW Process:

Welding of weld joint – 171 located on PCMK SSD27-PP057, Partial diaphragm at 7DE FL3. Welder is identified as 222396. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232T.

FCAW Process:

Welding of weld joint – 118 located on PCMK SSD27-PP057, Partial diaphragm at 7DE FL3. Welder is identified as 220067. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

FCAW Process:

Welding of weld joint – 138 located on PCMK SSD27-PP057, Partial diaphragm at 7DE FL3. Welder is identified as 220068. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

OBG # TRIAL ASSEMBLY YARD (7DE-7EE)

SMAW Process:

Welding of weld joint – 053 and 054 located on PCMK BP065-001, bottom panel T-Rib hold back welds of segment 7DE and 7EE. Welder is identified as 037998. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # TRIAL ASSEMBLY YARD (7CE-7DE)

SMAW Process:

Welding of weld joint – 021 located on PCMK DP656-001, Deck panel I-Rib weld joins segment 7CE and 7DE. Welder is identified as 054467. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
